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ABSTRACT OF THE INVENTION

~~A flat electrical cable and a modular rotary anvil for assembling a flat electrical cable is~~
provided wherein the flat cable includes an upper layer having ribs protruding along its length and
substantially parallel to one another, continuous substantially parallel and adjacent seams formed
(between and upper an lower insulator layer conductors between the upper and lower layer adjacent
the seams] and a pattern formed in the surface of the lower insulator layer. The present invention
may have upper and lower polyester layers having copper conductors therebetween and the seams
ultrasonically welded in order to provide flat electrical cable for various applications such as
incorporation in an automobile clockspring. The modular rotary anvil includes multiple removable
and interchangeable segments or inserts which provide the ability to impart a smooth or knurled
textured surface pattern to the work-piece. Other inserts include cutting inserts which provide for a
seam on the work-piece while at the same time cuts the work-piece along a seam.